

Auto. Lid

Ship 22 Feb.

Work Order ID 141193

141193

Page 1

Friday, January 29, 2016 3:39:50 PM

Item ID: D205-541-044A

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/19/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: 16-2-01 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9710	

DAS
6
9-89

MCS 16-02-19

100 Document Control 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD205-541-044A

CHG001

DAS
28
9-89

FEB 22 2016

110 Small Fab 0.00

110

Small Fab

Small Fab

Memo

0.03

Small Fab

Assemble as per Dwg.

16-01-29 *** Install gas spring as per ASI9710 ***

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

16-02-19

16-02-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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NR1

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NR2

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

DAS

6

9-89

FEB 18 2016

DAS

27

9-89

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

DAS

28

9-89

FEB 22 2016

150

Packaging

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-541-044A

Location: _____

PPP Rev: _____

DAS

28

9-89

FEB 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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NR1

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Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

FEB 22 2016

FEB 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Friday, January 29, 2016 3:39:55 PM

141193

D205-541-044A

Required Date: 2/19/2016

Required Qty: 1.00

Comments: IPP REV:A 16.01.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-541-051		Manufactured	No				Each	0.0000		1			
D205-541-051 110 Automatic Lid Opener ** 1/4/204 DAS 6 9-89													
NAS1149D0432J		Purchased	No				Each	446.0000		4			
NAS1149D0432.J 130 WASHER **													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
		DAS 28 9-89		GA			213						DAS 6 9-89
				m131026			213						
				ST269			233						
				m131026			233			4			
NAS1149D0532J		Purchased	No				Each	188.0000		2			
NAS1149D0532.J 130 WASHER **													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
		DAS 28 9-89		ST269			188						DAS 6 9-89
				m131467			188			2			
D2512		Manufactured	No				Each	0.0000		1			
D2512 110 Basket Lid ** FEB 18 2016													
D3053-042		Manufactured	No				Each	0.0000		1			
D3053-042 110 212 Basket Base Assembly ** 3/4/206 (12/16/02/19													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Picklist Print

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Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

D2022-101

Manufactured No

Each

141.0000

2

D2022-101 /101

DAS

Spacer

6

9-89

Location

Loc Qty

Loc Code

ST001

5

107903

5

ST012a

136

132703

90

140201

46

Each

141.0000

2

D2022-101

Manufactured No

D2022-101

Spacer

Location

Loc Qty

Loc Code

ST001

5

107903

5

ST012a

136

132703

90

140201

46

Each

12.0000

1

D2258-300

Manufactured No

D2258-300 /110

Placard

Location

Loc Qty

Loc Code

ST004

12

139698

12

DAS

6

9-89

FEB 18 2016

DQA: _____ Date: _____



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D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

D2332-041

Manufactured No

Each 8.0000 1

D2332-041

Lid Prop Assembly 6.69"

Location	Loc Qty	Loc Code
FG	2	
132567	1	
89226	1	
ST367	6	
134190	6	

D2530

Manufactured No

Each 2.0000 1

D2530

Handle Weldment

Location	Loc Qty	Loc Code
ST379	2	
139447	2	

137070

DAS
6
9-89

D2535

Manufactured No

Each 82.0000 2

D2535

Spring

Location	Loc Qty	Loc Code
ST008	7	
137337	7	
ST012a	75	
138588	25	
139657	50	

2

DAS
6
9-89

D2537

Manufactured No

Each 39.0000 2

D2537

Bushing

Location	Loc Qty	Loc Code
ST008	39	
137921	19	
139004	20	

2

DAS
6
9-89

FEB 18 2016

Friday, January 29, 2016 3:39:56 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

D2931

Manufactured No

Each

1,633.000

2

D2931

Bumper

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST013

10

86435

10

ST025A

1623

86435

1623

Each

129.0000

2

**

DAS
6
9-89

AN3-16A

Purchased

No

AN3-16A

Bolt

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

84

M133790

84

Each

137.0000

2

**

DAS
6
9-89

AN4-7A

Purchased

No

AN4-7A

Bolt

Location

Loc Qty

Loc Code

over003

100

m133790

100

ST325

37

m131320

37

FEB 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-22A

Purchased No

Each

147.0000

1

AN4-22A

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

50

116419

50

ST342

97

123348

97

Each

76.0000

1

DAS

6

9-89

Location

Loc Qty

Loc Code

ST342

21

M126175

21

ST343

55

128403

55

Each

149.0000

4

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

36

117872

36

ST337

113

m133077

13

m134055

100

AN5-17A

Purchased No

Each

149.0000

4

AN5-17A

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

36

117872

36

ST337

113

m133077

13

m134055

100

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

5,435.000

2

NAS1149D0463.J 110

DAS

6

~~9-89~~

WASHER

Location

Loc Qty

Loc Code

GA	397	
M129390	41	
M132035	356	
ST260a	2000	
M134039	2000	
ST263	1689	
M134039	1689	2
ST269	1349	
M130799	361	
M132317	100	
M132677	888	

NAS1149D0416J

Purchased

No

Each

4,466.000

2

NAS1149D0416.J 110

DAS

6

~~9-89~~

WASHER

Location

Loc Qty

Loc Code

GA	300	
m131511	300	
ST260a	1986	
m131511	1986	
ST264	2180	
m131511	2180	2

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

Each

1,410.000

4

NAS1149D0563.J

Washer

110

Location

Loc Qty

Loc Code

DAS

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

354

m133363

154

m133938

200

ST269

103

m128257

103

AN970-4

Purchased

No

Each

199.0000

4

AN970-4

Washer

110

Location

Loc Qty

Loc Code

ST260a

100

m133769

50

m133992

50

ST329

99

m133235

49

m134039

50

FEB 18 2016

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,453.000

2

MS21042L3 ✓ 110

Nut

Location

Loc Qty

Loc Code

DAS
6
9-89

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

95

m133790

95

MS21042L4

Purchased

No

Each

3,356.000

4

MS21042L4 ✓ 110

Locknut

Location

Loc Qty

Loc Code

DAS
6
9-89

FP001

41

m133363

41

GA

26

m127813

26

ST007

1500

m134055

1500

ST303

1692

m133769

1692

ST305

97

m130922

97

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

Each

702.0000

4

MS21042L5 ✓ 110

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST007

400

m134055

400

ST303

156

m133577

56

m133790

100

Each

368.0000

2

MS20600-AD4W3

Purchased

No

MS20600-AD4W3 ✓ 110

Cherry Rivets

Location

Loc Qty

Loc Code

GA

184

m129795

184

ST308

50

m133316

50

WA003

134

m130018

84

m133316

50

Each

2.0000

1

D2199-1

Manufactured

No

D2199-1 130

Struts, 19"

Location

Loc Qty

Loc Code

ST352

2

132744

1

137412

1

DAS
28
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

D2515 Manufactured No

Each 10.0000 2

D2515 130

Bushing

DAS
28
9-89

Location

Loc Qty

Loc Code

ST007

10

137401

10

2

DAS
6
9-89

DAS
27
9-89

D3052-1 Manufactured No

Each 7.0000 1

D3052-1 130

Mounting Lug

DAS
28
9-89

Location

Loc Qty

Loc Code

ST536

7

137493

1

40200

6

1

DAS
6
9-89

DAS
27
9-89

AN4-7A Purchased No

Each 137.0000 2

AN4-7A 130

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

100

m133790

100

ST325

37

m131320

37

2

DAS
6
9-89

DAS
27
9-89

AN5-13A Purchased No

Each 48.0000 1

AN5-13A 130

BOLT

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

2

m129682

2

GA

11

122800

11

ST338

35

m132803

35

1

DAS
6
9-89

DAS
27
9-89

FEB 18 2016

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Page 11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Page 12

Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

Each

434.0000

9

AN4-13A

130

Bolt

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

over003

50

m134039

50

ST344

364

m133998

364

9
2

AN4-14A

Purchased

No

Each

734.0000

AN4-14A

130

Bolt

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

over003

500

M133998

500

ST344

229

M133316

15

M133769

214

2
1

AN5-7A

Purchased

No

Each

4,117.000

AN5-7A

130

Bolt

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

over009

4117

M119017

2400

M123355

1510

M123532

7

m126010

200

1

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Page 12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

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Page 13

Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

5,435.000

33

NAS1149D0463.J /30

WASHER

DAS
27
6 9-89
9-89

Location

Loc Qty

Loc Code

GA	397	
M129390	41	
M132035	356	
ST260a	2000	
M134039	2000	
ST263	1689	
M134039	1689	33
ST269	1349	
M130799	361	
M132317	100	
M132677	888	

DAS
28
9-89

NAS1149D0563J

Purchased

No

Each

1,410.000

5

NAS1149D0563.J /30

Washer

FEB 18 2016

Location

Loc Qty

Loc Code

GA	53	
m125807	53	
ST260a	900	
m133769	400	
m133990	500	
ST263	354	
m133363	154	
m133938	200	5
ST269	103	
m128257	103	

DAS
28
9-89

DAS
27
6 9-89
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 14

Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

3,356.000

16

MS21042L 4

130

Locknut

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST007

1500

m134055

1500

ST303

1692

m133769

1692

ST305

97

m130922

97

16

D2499

Manufactured

No

Each

13.0000

1

D2499

130

Mounting Bracket

DAS
6 27
9-89 9-89

FEB 18 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST472

2

103021

2

ST527

11

132820

10

137488

1

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Page 15

Work Order ID: 141193

141193

Parent Item: D205-541-044A

D205-541-044A

Parent Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016

Required Date: 2/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

Each

702.0000

2

MS21042L5

130

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST007

400

m134055

400

ST303

156

m133577

56

m133790

100

Each

769.0000

2

NAS1149DN832J

Purchased

No

NAS1149DN832J

130

Washer

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST270

685

M131697

685

DAS
28
9-89

DAS
27
6
9-89

DAS
27
6
9-89
FEB 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																														
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																										
Root Cause		FAULT CATEGORY																																																																
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐																																																																	

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4**
REF. TCCA STC SH96-120,
FAA STC SR00696NY
EASA STC EASA.IM.R.S.01242

1.0 Purpose:

The purpose of this DSI is to provide operators of Bell 205/210/212/214/412 Rotorcraft equipped with Dart D205-541-043/-044/-045/-046 Heli-Utility-Baskets with an Upgrade Kit to replace the existing Lid Prop Arm Assembly with an Automatic Lid Opening Gas Spring Kit. The D205-541-051 Automatic Lid Opener Kit includes parts and hardware to install a gas spring on both ends of the basket.

2.0 Parts List:

ITEM No.	QTY -051	PART NUMBER	DESCRIPTION
	X	D205-541-051	AUTOMATIC LID OPENER KIT
1	4	D3953-3	GAS SPRING STUD
2	4	D3953-7	GAS SPRING SPACER
3	4	D3953-9	GAS SPRING WASHER
4	6	D3953-17	GAS SPRING SPACER
5	2	D3953-19	GAS SPRING BRACKET
6	2	D3953-21	GAS SPRING BRACKET
8	2	D3989-3	GAS SPRING
9	4	AN3-14A	BOLT
10	4	AN3-20A	BOLT
11	4	AN310-4	CASTELLATED NUT
12	8	MS21042L3	NUT
13	4	MS24665-231	COTTER PIN
14	16	NAS1149F0363P	WASHER
15	4	NAS1149F0463P	WASHER

*Note:

For customers wishing to order new baskets with the Lid Opener pre-installed, use the following numbers:

D205-541-043 BASKET with AUTOMATIC LID OPENER installed = D205-541-043A
D205-541-044 BASKET with AUTOMATIC LID OPENER installed = D205-541-044A
D205-541-045 BASKET with AUTOMATIC LID OPENER installed = D205-541-045A
D205-541-046 BASKET with AUTOMATIC LID OPENER installed = D205-541-046A

3.0 PROCEDURE:

For D205-541-043/-044/-045/-046 Heli-Utility Baskets, replace the existing Prop Arm Assembly with gas springs on both ends of the basket.

(NOTE: Once this modification is complete, it will not be possible to re-install the D2332-041 Prop Arm Assembly)

3.1 Remove the D2332-041 Prop Arm Assembly.

3.2 Grind flush the D2327-3 Spacer Bushing from the end of the basket base. Touch up paint per ICA-D205-541, Section 5.1.5.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
	D. SHEPHERD (DE # 02)
DATE:	15.02.23
CERT. NO.:	SH96-120
ISSUE NO.:	3

A	NEW ISSUE	DB	15.02.23
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9710	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTALLATION	NTS
DATE	15.02.23	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- 3.3 Locate the D3953-17 Gas Spring Spacer on the basket lid per Figure 1 (-043/-044) or Figure 2 (-045/-046). Trim steel mesh locally as required. Transfer mark and drill 2X $\varnothing 0.194$ holes thru basket lid. Touch up paint per ICA-D205-541, Section 5.1.5. (Later model D2512 Basket Lids may be pre-drilled for gas spring brackets)
- 3.4 Install D3953-17 Gas Spring Spacer (qty 2) and D3953-19 Gas Spring Bracket to the basket lid using 2X AN3-20A bolts, NAS1149F0363P Washers and MS21042L3 Nuts as shown in Figure 3.
- 3.5 Locate the D3953-17 Gas Spring Spacer on the basket base as shown in Figure 1 (-043/-044) or Figure 2 (-045/-046). Trim steel mesh locally as required. Transfer mark and drill 2X $\varnothing 0.194$ holes thru the basket base. Touch up paint per ICA-D205-541, Section 5.1.5.
- 3.6 Install the D3953-17 Gas Spring Spacer and D3953-21 Gas Spring Bracket to the basket base using 2X AN3-14A bolts, NAS1149F0363P Washers and MS21042L3 Nuts, as shown in Figure 3.
- 3.7 Insert D3953-3 Gas Spring Studs through the D3953-19 and D3953-21 Gas Spring Brackets from the inside of the basket. (May be performed prior to 3.6 if necessary because of basket mesh).
- 3.8 Install a D3953-7 Spacer on to each stud followed by the D3969-3 Gas Spring, D3953-9 Gas Spring Washer, NAS1149F0463P Washer and AN310-4 Castellated Nut. To secure the nut, install a MS24665-231 Cotter Pin into the D3953-3 Gas Spring Stud. Install the Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
NOTE: With the Lid in the closed position, the Gas Spring should **NOT** be fully compressed
- 3.9 Repeat the installation on the opposite end of the basket.
- 3.10 Test the installation. If installed properly, the Gas Springs should assist in both opening and closing the basket lid.

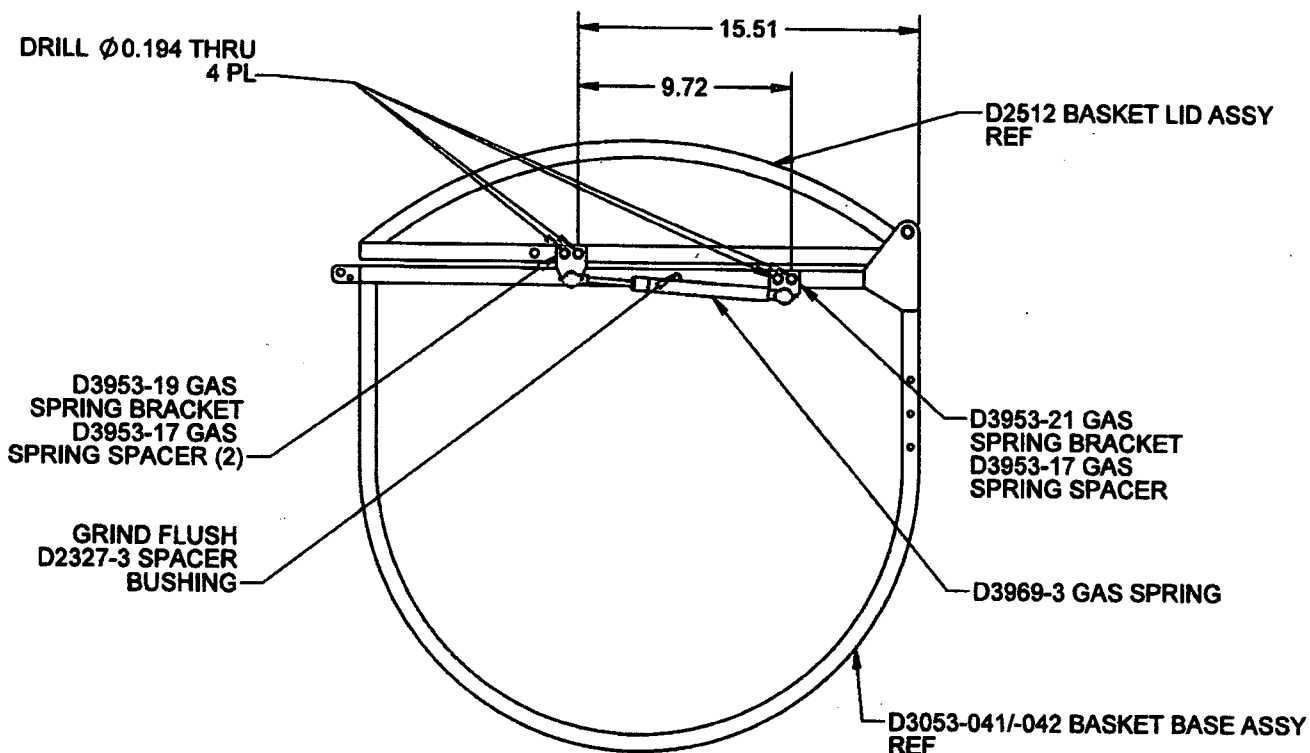


FIGURE 1: D205-541-051 AUTOMATIC LID OPENER INSTALLATION
(ON D205-541-043/-044 HELI-UTILITY BASKET, BOTH ENDS)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.02.23
CERT. NO.: SH96-120
ISSUE NO.: 3

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9710	SHEET 2 OF 4
APPROVED	ES	TITLE	SCALE
DE APPR.	17	AUTOMATIC LID OPENER INSTALLATION	NTS
DATE	15.02.23	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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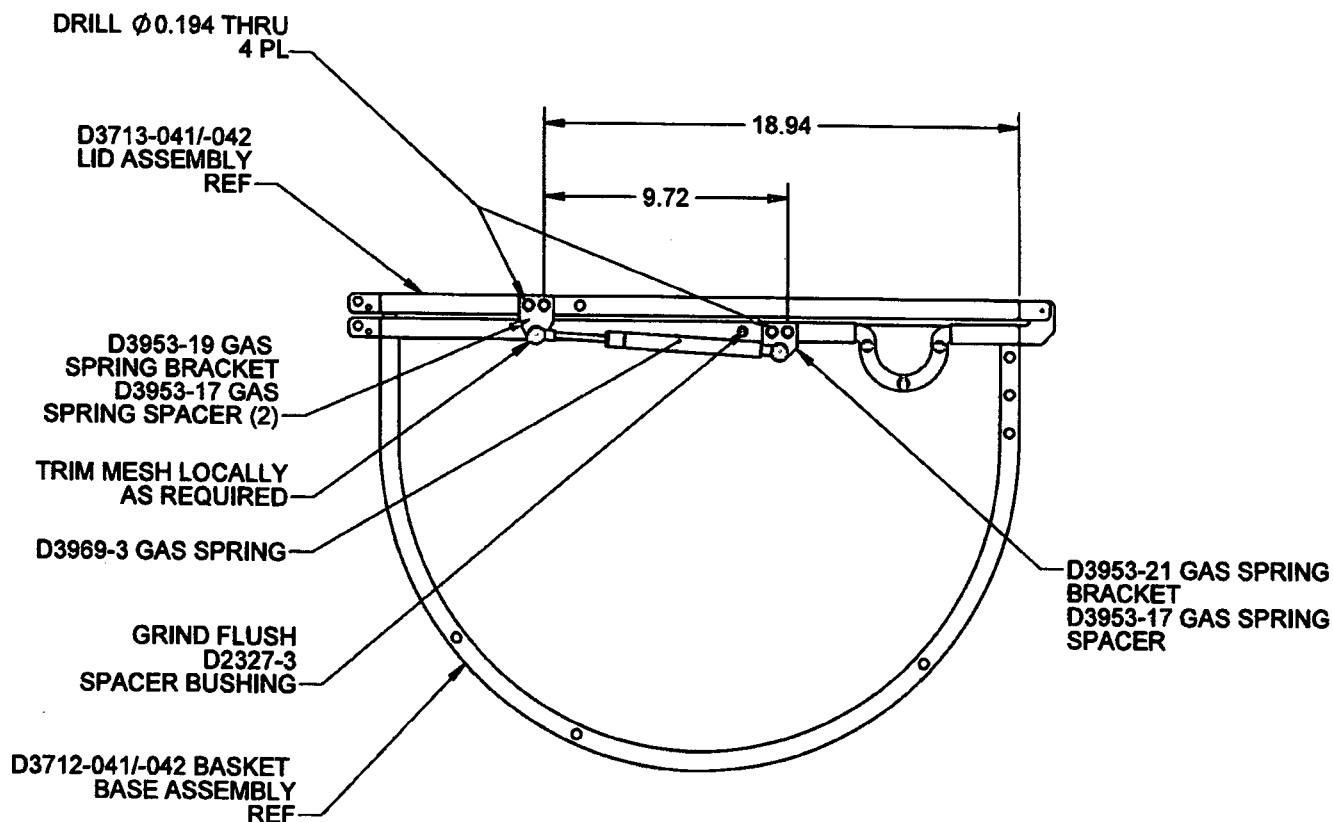


FIGURE 2: D205-541-051 AUTOMATIC LID OPENER INSTALLATION
(ON D205-541-045/-046 HELI-UTILITY-BASKET, BOTH ENDS)
(MESH NOT SHOWN FOR CLARITY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.02.23
CERT. NO.: SH98-120
ISSUE NO.: 3

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9710	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTALLATION NTS	
DATE	15.02.23	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

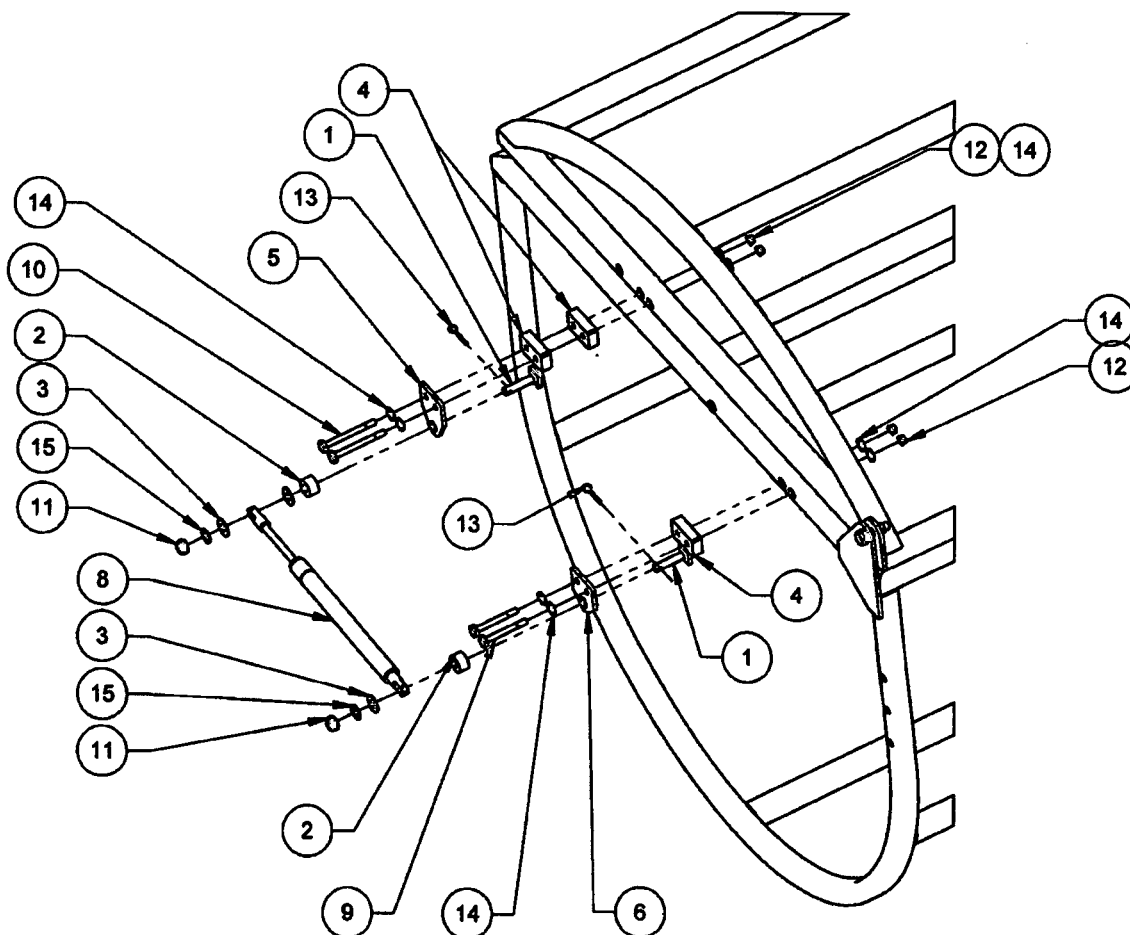


FIGURE 3: D205-541-051 GAS SPRING KIT INSTALLATION
 (ON D205-541-043/-044: LH SIDE, AFT END SHOWN/RH SIDE AND FWD END SIMILAR)
 (MESH NOT SHOWN FOR CLARITY)

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-051	0.66 lb	- 63.13 in	- 41.7 in-lb	132.25 in	87.3 in-lb
<i>Automatic Lid Opener Kit</i>	0.30 kg	- 1.60 m	- 0.5 m-kg	3.36 m	1.0 m-kg

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 15.02.23
 CERT. NO.: SH96-120
 ISSUE NO.: 3

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	DB		
CHECKED	J	DRAWING NO. DSI 9710	SHEET 4 OF 4
MFG. APPR.	N/A	TITLE AUTOMATIC LID OPENER INSTALLATION	SCALE NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>		
DATE	15.02.23		

Work Order ID 141193

Friday, January 29, 2016 3:39:50 PM

Auto. Lid

141193

Ship 22 Feb.

Page 1

Item ID: D205-541-044A

Revision ID:

Item Name: Heli-Utility-Basket™ with Automatic Lid Opener - RH

Start Date: 2/1/2016 Start Qty: 1.00

Required Date: 2/19/2016 Req'd Qty: 1.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 16-2-01

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

Photocopy bluefile & type labels per PPPD205-541-044A

CHG001

Small Fab

0.00

Memo

Assemble as per Dwg.

0.03

*** Install gas spring as per AS19710 ***

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

120

lity Control

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kG	132.25 in 3.36 m	15606 in-lb 180.1 m-kG
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kG	132.25 in 3.36 m	15606 in-lb 180.1 m-kG
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kG	132.25 in 3.36 m	13754 in-lb 158.9 m-kG
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kG	132.25 in 3.36 m	13754 in-lb 158.9 m-kG
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-kG	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kG
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-kG	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kG
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-kG	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kG
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-kG	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kG

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X						D205-541-043	HELI-UTILITY-BASKET, LH
	X					D205-541-044	HELI-UTILITY-BASKET, RH
		X				D205-541-045	HELI-UTILITY-BASKET, LH
			X			D205-541-046	HELI-UTILITY-BASKET, RH
				X		D205-541-141	HELI-UTILITY-BASKET, LH
					X	D205-541-142	HELI-UTILITY-BASKET, RH
				1	1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*					D2512	BASKET LID ASSEMBLY

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Revision: J
Date: 10.03.08

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
		6*	6*			D3723-1	BUSHING
				2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
				1	1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
				2	2	D4052-1	EYE BOLT
				10	10	AN3-5A	BOLT
				1	1	AN3-7A	BOLT (OPTIONAL)
				4	4	AN3-11A	BOLT (OPTIONAL)
2*	2*	2*	2*			AN3-16A	BOLT
				5	5	AN4-6A	BOLT
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: J

Date: 10.03.08

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4

REF TCCA STC: SH96-120

REF FAA STC: SR00696NY

REF EASA STC: EASA.IM.R.S.01242

PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)**5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)**

QTY -043	QTY -044	QTY -045	QTY -046	PART NUMBER	DESCRIPTION
X				D205-541-043	HELI-UTILITY-BASKET-LH
	X			D205-541-044	HELI-UTILITY-BASKET-RH
		X		D205-541-045	HELI-UTILITY-BASKET-LH
			X	D205-541-046	HELI-UTILITY-BASKET-RH

ADD:

4	4	4	4	NAS1149D0463J	WASHER
4	4	4	4	NAS1149D0432J	WASHER
2	2	2	2	NAS1149D0532J	WASHER
2	2	2	2	NAS1149D0563J	WASHER

WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

MAINTENANCE:

PER ICA-D205-541.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: [Signature]
D. SHEPHERD (DE # 02)
DATE: 14.11.27
CERT. NO.: SH96-120
ISSUE NO.: 3

A	NEW ISSUE	DW	14.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9667	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	WASHER ADDITION	NTS
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